







Date: Friday, 11/18/2005 1:23:54 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET
Job Number : 24772	
Estimate Number : 10398	
P.O. Number : N/A	Part Number : D31561
This Issue : 11/18/2005 S.O. No. : NA	Drawing Number : D3156 REV B
Prsht Rev. : NC	Project Number : NA
First Issue : N/A Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 24706	Material : N/A
Written By : <u>See comment below</u>	Due Date : 12/20/2005
Checked & Approved By : <u>See comment below</u>	Qty: 10 Um: Each
Comment : Est A 04.11.30 New issue KJ/JLM	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation: Description :
1.0	M2024T3S050 2024-T3 .050 sheet
	
Comment: Qty.: 0.4739 sf(s)/Unit Total : 2.3693 sf(s) Note: To be made in multiples of 10 Material: 2024-T3 (QQ-A-250/4) 0.050" thick (M2024T3S.050) Batch: <u>M 17053</u> <u>Ed 05/12/12 10</u>	
2.0	SHEAR SHEAR
	
Comment: SHEAR Cut blank: 1.950" x 0.700" grain along 1.950" <u>Ed 05/12/12 10</u>	
3.0	HAAS1 HAAS CNC VERTICAL MACHINING #1
	
Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per Folio FA477 and Dwg D3156 Stack of 10 Identify as D3156-1 <u>Ed 05/12/12 10</u>	
4.0	QC2 INSPECT PARTS AS THEY COME OFF MACHINE
	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>Ed 05/12/12 10</u>	
5.0	QC8 SECOND CHECK
	
Comment: SECOND CHECK <u>Ed 05/12/12 10</u>	

p10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D31561 PAR #: _____ Fault Category: Production/machine parts NCR: (Yes) No DQA: [Signature] Date: 05/12/16
 QA: N/C Closed: [Signature] Date: 05.12.16

NCR: <u>24772</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>05/12/12</u>	<u>#3.0</u>	<u>3 stacks (30 parts) SCRAP. moved in clamp</u>	<u>[Signature]</u> <u>05/12/12</u>	<u>SCRAP + destroy and Replace</u>	<u>En</u> <u>05/12/12</u>	<u>[Signature]</u> <u>05-12-12</u>	<u>[Signature]</u> <u>05/12/12</u>	<u>[Signature]</u> <u>05-12-12</u>

NOTE: Date & initial all entries

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Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr

SB 05/12/12

10

7.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
Form as per Dwg D3156

SB 05/12/12

10

8.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

05.12.13

10

9.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

FF 05.12.14

10

10.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT CHEMICAL CONVERSION COAT

05.12.14

10

11.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Identify with P/N and B/N using a permanent fine point marker, then Stock
Location: CA-18

SB 05/12/15

10

CY 05/12/15

10

12.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL
Inspection Level 21

545 05/12/16

10

05/12/16

10

Job Completion



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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 17, 2005
03:30 pm

Work Order No	:	0024772	Department Code:	
Project Name	:	D3156-1	Burden Flags	: NNNNNNN
Project For	:	WK550	WO Status	: Open
Work Order Type	:	Main	Invoice State	: Not Invoiced
Main WO Number	:		Invoice Date	:
House Part Number	:	D3156-1	Invoice Number	:
Description	:	Bracket	Invoice Amount	: 0.00
Manufactured	:	Yes		
Amount Req'd	:	5	Order Entry No	:
Amount Done	:	0	OE Value	: 0.00
Start Date	:	11-17-05		
Est Finish Date	:	12-10-05	Est Margin	: 0.000%
Act Finish Date	:		Actual Margin	: 0.000%
Drawings Req'd	:	No		
Ok for Approval	:			
Approval Rec'd	:		\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

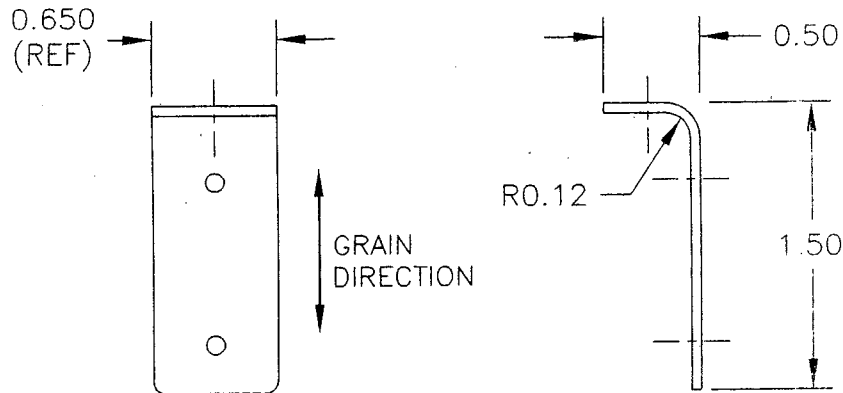
	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00

CONTROLLED COPY

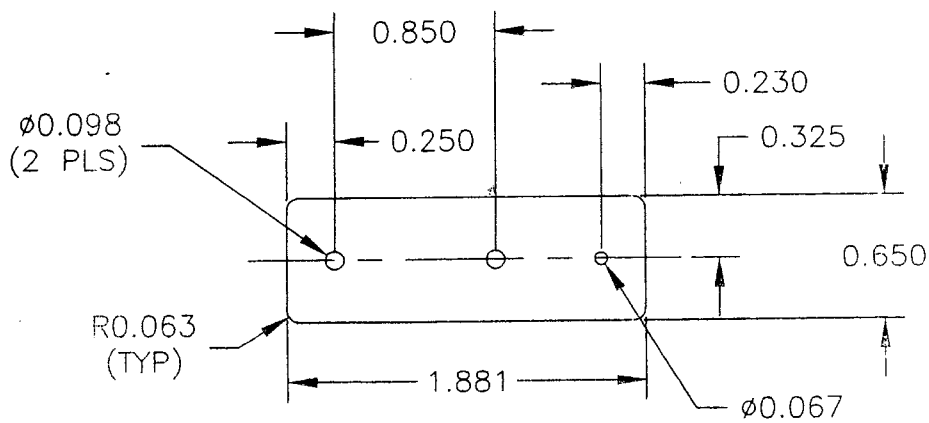


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3156	REV. B SHEET 1 OF 1
DATE 04.10.18		TITLE BRACKET	SCALE 1:1
A	02.04.24	NEW ISSUE	
B	04.10.18	ADD PART MARKING	

RELEASED
04.11.23



D3156-1 BRACKET



D3156-1 BRACKET FLAT PATTERN

NOTES:

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.050 THICK (REF. DART SPEC. M20247 3.053)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) POSSIBLE SUPPLIER: PREMIER P/N B30-23000-117
- 7) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

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